

Date: Wednesday, 2/15/2006 3:49:37 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE KIT
Job Number	: 25854		
Estimate Number	: 10532		
P.O. Number	: N/A	Part Number	: K10003
This Issue	: 2/15/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: K10003 REV B
First Issue	: N/A	Project Number	: N/A
Previous Run	: 25618	Drawing Revision	: B
		Material	: N/A
Written By	: <u>See Comment Below</u>	Due Date	: 3/3/2006
Checked & Approved By	: <u>06.02.16</u>	Qty:	8 Um: Each
Comment	: Est: 1 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels per PPP K10003CHG004 for D205-634-011 and D204-635-011

Dt 06/02/08

2.0	D2570	Bushing
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Comment: Qty.: 24.0000 Each(s)/Unit Total: 192.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
24	D2570	Bushing	B25008

(192)

3.0	D2571	Saddle, Fwd, Out
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Saddle, Fwd, Out

Pick:

Qty	Part Number	Description	Batch
1	D2571	Saddle	5XB25016/3XB25829

(8)

4.0	D2572	Saddle, Fwd, In
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Saddle, Fwd, In

Pick:

Qty	Part Number	Description	Batch
1	D2572	Saddle	B25831

(8)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2573

Saddle, Aft, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Saddle, Aft, Out

Pick:

Qty	Part Number	Description	Batch
1	D2573	Saddle	B25619

(8)

6.0

D2574

Saddle, Aft, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Saddle, Aft, In

Pick:

Qty	Part Number	Description	Batch
1	D2574	Saddle	B25619 1XB 25862/7XB 25620

(8)

7.0

D27361

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Lug Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2736-1	Bracket	B24064 ✓

(8)

8.0

D27363

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Lug Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2736-3	Bracket	B23687 1mcp ✓ B24375 7mcp ✓

(8)

9.0

D2747

Set Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Set Screw

Pick:

Qty	Part Number	Description	Batch
4	D2747	Socket Head Set Screw	B24312 4mcp B24693 28mcp

(32)

Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D2876

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)
Saddle Spacer

(16)

Pick:

Qty	Part Number	Description	Batch
2	D2876	Spacer	B22182

11.0

D2877

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)
Saddle Spacer

(16)

Pick:

Qty	Part Number	Description	Batch
2	D2877	Spacer	B22979

12.0

D2968041

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
Tow Ring

(8)

Pick:

Qty	Part Number	Description	Batch
1	D2968-041	Tow Ring	B23761

13.0

AN46A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 128.0000 Each(s)
Bolt

(28)

Pick:

Qty	Part Number	Description	Batch
16	AN4-6A	Bolt	M18275 78M4 M15204 48M4 2x M19278

14.0

AN446A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)
Bolt

(32)

Pick:

Qty	Part Number	Description	Batch
4	AN4-46A	Bolt	M19714

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Seq. #:

Machine Or Operation:

Description :

15.0

AN451A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

8 AN4-51A Bolt M17243

(64)

16.0

AN612A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch M1807956 mcs

8 AN6-12A Bolt M14764-8 mcs

(64)

17.0

AN960JD416

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 256.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch M19085-22 mcs

32 AN960JD416 Washer M15321 30 mcs

(256)

18.0

AN960JD616

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch M1908 22 mcs

8 AN960JD616 Washer M13658 8 mcs M18369 34 mcs

(64)

19.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch M15199 ymcs

1 AN970-4 Washer M18918 ymcs

(8)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: LD Date: 26/03/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

MS21042L4

Nut



Comment: Qty.: 29.0000 Each(s)/Unit Total : 232.0000 Each(s)

Nut

Pick:

Qty

Part Number

Description

Batch

29

MS21042L4

Nut (or MS21042-4)

M17997 180

M15020 18mcp

M14764 34mcp

(232)

21.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

0206/03/22

(8)

22.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

REV G

04/3/22

(8)

23.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP

06/03/23

Job Completion {



06.03.23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>A</i>	DRAWN BY <i>A</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>A</i>	DRAWING NO. K10003	REV. B SHEET 1 OF 1
DATE 00.11.22		TITLE SADDLE KIT	SCALE NTS
A	00.06.01	NEW ISSUE	
B	00.11.22	ADD D2707-041 OPTION	

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 205/ 212 /412	D205-634-011 D205-634-015
BELL 204	D204-635-011

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

PART NUMBER	K10003	D205-634-011 D205-634-015	D204-635-011
D205-641-011	1	1	1
D2570	16	16	16
D2571	1	1	1
D2572	1	1	1
D2573	1	1	1
D2574	1	1	1
D2747	4	4	4
D2876	2	2	2
D2877	2	2	2
D2707-041 (or D2968-041)	1	1	1
AN4-51A	8	8	8
AN4-6A	16	16	16
AN6-12A	8	8	8
AN960JD416	32	32	32
AN960JD616	8	8	8
*AN960JD1016	1	1	1
AN970-4	1	1	1
MS21042-4 (OR L4)	25	25	25

* REQUIRED WITH D2707-041 ONLY

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25854

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